

## WHAT IS CLAIMED IS:

1. A process for manufacturing a cylindrical container, the process comprising the steps of:

5 drawing and ironing, using a press, at least two metal shells;  
forming the container using the at least two metal shells; and,  
attaching a valve portion to the container via a brazing process.

2. The process of claim 1, wherein the container has a sidewall, the  
10 sidewall having a thickness, the process further comprises the step of:  
specifying the thickness of the sidewall to withstand hydrostatic pressure.

3. The process of claim 2, wherein the process further comprising  
the step of:  
15 maintaining a substantially consistent thickness via a substantially uniform  
clearance between the container and an ironing ring.

4. The process of claim 1, wherein drawing and ironing, using a  
press, at least two metal shells further comprises the step of:  
20 drawing and ironing, using a hydraulic press, at least two metal shells.

5. The process of claim 1, wherein drawing and ironing, using a  
press, at least two metal shells further comprises the step of:  
drawing and ironing, using a mechanical press, at least two metal shells.  
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6. The process of claim 3, wherein the method further comprises the  
step of:  
attaching a base to the container.

7. The process of claim 6, wherein the process further comprises the  
step of:  
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increasing the thickness with each run through the process.

8. The process of claim 7, wherein the container is a cylindrical container.

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9. A cylindrical container, the container comprising:  
a body, the body being formed by a drawing and ironing process; and,  
a valve portion, the valve portion being attached to the body via a brazing process.

10. The container of claim 9, wherein the body has a thickness, the thickness being enough to withstand hydrostatic pressure.

11. The container of claim 10, wherein the container further comprises a base, the base attached to the bottom of the container.

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12. The container of claim 11, wherein the container is a cylindrical container.

13. A cylindrical container made in accordance with the process of claim 1.

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